

Work Order ID 73428

Page 1

Wednesday, August 31, 2011 3:17:51 PM

Item ID: K642-511

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-511

Start Date: 8/31/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/09/01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9467	Rev A								
IIN D206-642	Rev N								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Create White labels per PPP K642-511	CHG004							
110	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

11-11-03 (2)
H. J. Miller MLT 11-10-18

11/10/17 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

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Picklist Print

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Page 1

Work Order ID: 73428

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 07.06.05 new issue EC
IPP Rev.B 08.02.05, Per ECN1080P LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C35A BOLT		Purchased	No			110	Each	65.0000	3	6			

Location

Loc Qty

Loc Code

FG

4

18914

4

ST352

16

117366

16

ST353

45

117872

25

118628

20

AN3C36A

Purchased

No

110

Each

138.0000

9

18

Location

Loc Qty

Loc Code

FG

14

101261

4

116590

10

FP-B

17

111925

17

ST353

107

118191

22

118451

20

118706

15

118757

50

118628

119083 108

11/19/20 84

119125

11/11/2011
11/19/20 84

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 2.00

Required Qty: 2.00

AN3C41A
BOLT
x2

Purchased No

110 Each 98.0000

8 16



M/19035

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

94

117950

19

118518

50

118757

25

AN4C6A
Bolt
x2

Purchased No

110 Each 349.0000

12 24



Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

345

116704

15

117872

30

118191

100

118451

200

AN5C11A
Bolt
x2

Purchased No

110 Each 164.0000

8 16



118451

11/11/07 (2)

Location

Loc Qty

Loc Code

FG

4

104817

4

ST337

110

117872

40

118706

70

ST338

50

118191

50

M/18706

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 73428

Parent Item: K642-511

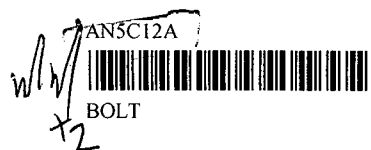
Parent Item Name: saddle kit 642-511

Start Date: 8/31/2011

Required Date: 9/16/2011

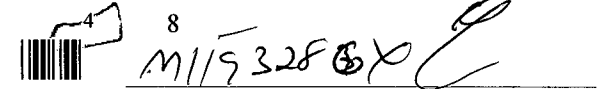
Start Qty: 2.00

Required Qty: 2.00



Purchased No

110 Each 67.0000



Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

65

117313

15

118451

50



Purchased No

110 Each 84.0000



Location

Loc Qty

Loc Code

FG

4

18918

4

ST338

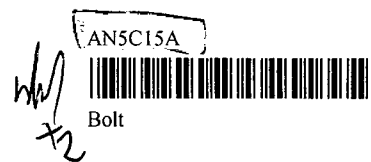
80

117313

30

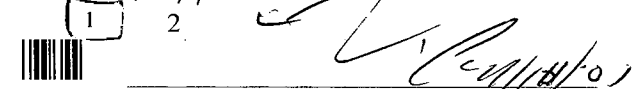
117872

50



Purchased No

110 Each 95.0000



Location

Loc Qty

Loc Code

ST338

23

118191

23

ST339

72

117885

22

118267

50

M11/8191

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 2.00

Required Qty: 2.00

AN5C32A

Purchased

No

110

Each

91.0000

2

4

Location

Loc Qty

Loc Code

FG

4

18918

4

ST340

87

116380

37

117407

25

117969

25

116380 34

117969 14

AN5C34A

Purchased

No

110

Each

48.0000

2

4

Location

Loc Qty

Loc Code

FG

2

18918

2

ST340

46

117763

21

117950

25

117950

AN5C35A

Purchased

No

110

Each

61.0000

1

2

Location

Loc Qty

Loc Code

ST340

36

108407

36

ST341

25

118451

25

108407

AN960C10L

NAS1149C0332

Purchased

No

110

Each

0.0000

24

48

washer

1119124

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: saddle kit 642-511

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 2.00

Required Qty: 2.00

W/h/ AN960C416L NAS1149C0532 Purchased No
 x2 WASHER
 AN960C516L NAS1149C0532 Purchased No
 WASHER
 D206-648-013 Manufactured No
 GHW Modification

110 Each 0.0000

24 48



M117291 L

110 Each 0.0000

8 16



M118384 L

110 Each 8.0000

1 2 -



74000 R

Location

Loc Qty

Loc Code

FG120

8

71578

2

72961

6

Manufactured No

110 Each 255.0000

16 32 -



71573 11/11/01 @

W/h/ D2652
 x2 Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST

201

53741

0

72120

201

ST019

10

71833

10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Work Order ID: 73428

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 2.00

Required Qty: 2.00

D2712

Manufactured No

110

Each

531.0000

10

20

Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

481

71160

181

72231

300

Manufactured No

110

Each

10.0000

1

2

D2932-1

Saddle LH Out, 206

Location

Loc Qty

Loc Code

ST428

10

69922

1

70874

4

72886

5

Manufactured No

110

Each

10.0000

1

2

D2933-1

Saddle LH In, 206

Location

Loc Qty

Loc Code

ST421

1

71062

1

ST428

9

70875

3

72884

6

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 73428

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/31/2011

Required Date: 9/16/2011


Start Qty: 2.00

Required Qty: 2.00

W/L
x2
D2934

Saddle Spacer

Manufactured No 110 Each 33.0000

 2 4
697402x

Location Loc Qty Loc Code

FG 6

31929 6


ST027 27

70772 27

Manufactured No 110 Each 25.0000

W/L
x2
D2935

Saddle Spacer


 2 4
70772 2x


Location Loc Qty Loc Code

ST027 25

70770 25

Manufactured No 110 Each 4.0000

W/L
x2
D2938-1

Saddle LH Out, 206


 1 2
70770
73468


Location Loc Qty Loc Code

ST428A 4

70862 4

Manufactured No 110 Each 5.0000

W/L
x2
D2939-1

Saddle LH In, 206

 1 2
73448 *11/11/01*

Location Loc Qty Loc Code

ST421 1

71056 1

ST428A 4

71873 4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 73428

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 2.00

Required Qty: 2.00

D3396-3

Manufactured No

110

Each

11.0000

2

4

Spacer

Location

Loc Qty

Loc Code

FG

10

26772

10

ST052

1

70983

1

Manufactured No

110

Each

8.0000

1

2

D3407-043

Tow Ring

Location

Loc Qty

Loc Code

ST463

6

70982

5

72513

1

ST464

2

68339

2

Manufactured No

110

Each

51.0000

1

2

D3456-1

Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

44

66848

3

71165

41

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 73428

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 2.00

Required Qty: 2.00

D3457-1
Washer
x2

Manufactured No

110

Each

56.0000

2

4

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

46

67779

1

71849

45

71849

D3672-1
Phenolic Washer
x2

Manufactured No

110

Each

1,178.000

24

48

Location

Loc Qty

Loc Code

ST074

1176

64177

180

66821

496

72229

500

72229

ST077

2

52505

2

D3672-3
Phenolic Washer
x2

Manufactured No

110

Each

767.0000

24

48

Location

Loc Qty

Loc Code

ST074

767

64176

225

71159

42

72230

500

72230

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 73428

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 2.00

Required Qty: 2.00

D3672-7

Manufactured No

110

Each

414.0000

24

48

Phenolic Washer

Location

Loc Qty

Loc Code

ST074

414

53237

244

64175

170

Purchased

No

110

Each

1,337.000

20

40

MS21043-3

Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1265

112314

6

118077

259

118614

500

118686

500

Purchased

No

110

Each

1,372.000

13

26

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1332

117793

476

118378

356

118686

500

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 2.00

Required Qty: 2.00

MS21043-5

Purchased

No

110

Each

504.0000

4

8

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

ST301

384

112314

284

116548

100

ST314

100

118159

100

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-511	SKIDTUBE INSTALLATION, LH
		X								D206-642-512	SKIDTUBE INSTALLATION, RH
			X							D206-642-515	SKIDTUBE INSTALLATION, LH
				X						D206-642-516	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-541	SKIDTUBE
						X				D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
							X			D206-642-549	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-551	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D3274-041	SKIDTUBE ASSEMBLY
1								1		D4362-041	SKIDTUBE ASSEMBLY
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		AN3C4A	* BOLT ⁽¹⁾
5A					2			2		NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
5B					2			2		D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1		1							D2932-1	* SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	* SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	* SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	* SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3C41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21043-3	NUT
12B	16	16	16	16						D3672-7	* WASHER (REPLACES NAS1515H5)
13	4	4	4	4						AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8	8	8	8						NAS1149C0532R	* WASHER (OR AN960C516L)
15B	8	8	8	8						D3672-7	* WASHER (REPLACES NAS1515H5L)
16	12	12	12	12						AN4C6A	BOLT
17A	24	24	24	24						D3672-3	* WASHER (REPLACES NAS1515H4L)
17B	24	24	24	24						NAS1149C0432R	* WASHER (OR AN960C416L)
18	12	12	12	12						MS21043-4	NUT
20A					9	9				D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A					1	1				D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A					1	1				D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B					1	1				D3536-15	* GASKET ⁽¹⁾
23A					1	1				D3535-23	* WEARSHOE ⁽¹⁾ (REPLACES D2656-23)
23B					1	1				D3536-23	* GASKET ⁽¹⁾
24A					1	1				D3535-39	* WEARSHOE ⁽¹⁾ (REPLACES D3287-1)
24B					1	1				D3536-39	* GASKET ⁽¹⁾
25A					1	1				D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B					1	1				D3536-35	* GASKET ⁽¹⁾
26A			8	8	78	78	8			AN3C4A	* BOLT ⁽¹⁾
26B			8	8	78	78	8			NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
26C			8	8	78		8			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	* TOW RING
32A	1	1	1	1						D3456-1	* WASHER
32B	2	2	2	2						D3457-1	* WASHER
33	1	1	1	1						MS21043-4	NUT
34			1	1	1					AN4C5A	BOLT
35			1	1	1					NAS1149C0463R	* WASHER (OR AN960C416)
36			1	1	1					D3413-1	RING
37	10	10	10	10						D2712	* SET SCREW
38	2	2	2	2						D2934	* SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER

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ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
40									2	D3414-041	LUG ASSEMBLY (GHW)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)
50	9	9	3	3						AN3C36A	BOLT
51	3	3	3	3						AN3C35A	BOLT
52	24	24	12	12						NAS1149C0332R	WASHER (OR AN960C10L)
53	24	24	12	12						D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12	6	6						MS21043-3	NUT
55	2	2	2	2						D3396-3	SPACER
56A	1	1	1	1						AN5C35A	BOLT
56B	1	1	1	1						AN5C15A	BOLT
60	2	2	2	2						AN5C32A	BOLT
61	2	2	2	2						AN5C34A	BOLT
62	4	4	4	4						MS21043-5	NUT
80							1	1		D4368-041	FWD WEARPLATE ASSY
81							1	1		D4368-043	AFT WEARPLATE ASSY
82A							1	1		D4383-1	WEARPAD
82B							1	1		D4383-3	WEARPAD
83							20	20		D3873-3	BUSHING
84								24		D3411-3	WASHER
85							2			D3275-1	SPACER
86A							6	6		AN3C40A	BOLT
86B							2	2		AN3C37A	BOLT
86C							2	2		AN3C36A	BOLT
87							10	10		MS21043-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 OR D4362-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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